

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020543**Date Inspected:** 12-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC)**Location:** Shanghai, China

CWI Name:	Shao Jian Yuan and Li Yan Hua			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	OBG Trial Assembly		

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) at Trial Assembly and Bay # 14.

OBG Trial Assembly: Segment 12AE

This QA Inspector performed Dimension Control Inspection for the Segment 12AE.

The Floor Beam (FB) flatness were verified and measured from East and West side of the FB at Panel Points (PP) 110. The QA Inspector measured the flatness using 1500mm Straight Edge at the following locations.

Counter Weight side: At locations A, B, C, D, E, F, G, H and I.

Cross Beam side: At locations A', B', C', D', E', F', G', H' and I'.

The measurements were recorded in the Dimension Control Plan (DCP) on a separate form and submitted to the Lead Inspector and Engineer for review and disposition.

Bay # 14: Segment 14 East

WELDING INSPECTION REPORT

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This QA Inspector observed the in-process welding by Flux Cored Arc Welding (FCAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as Seg3019BB-157. The welder identification was 066763 and observed welding in the 3G (Vertical) position using approved Welding Procedure Specification WPS-B-T-2233-ESAB. The piece mark was identified as the weld connecting the Vertical Shear Plate sub assembly identified as SA3364 to Anchorage Plate AP3031A.

Please reference the pictures attached for more comprehensive details.

Bay # 14: Segment 14 East

This QA Inspector observed the in-process welding by Flux Cored Arc Welding (FCAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as Seg3019BB-069. The welder identification was 067877 and observed welding in the 3G (Vertical) position using approved Welding Procedure Specification WPS-B-T-2233-ESAB. The piece mark was identified as the weld connecting the Vertical Shear Plate sub assembly identified as SA3360 to Anchorage Plate AP3031A.

Bay # 14: Segment 14 East

This QA Inspector observed the in-process welding by Flux Cored Arc Welding (FCAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as Seg3019U-002. The welder identification was 067079 and observed welding in the 3G (Vertical) position using approved Welding Procedure Specification WPS-B-T-2233-ESAB. The piece mark was identified as the weld connecting the Anchorage Plate AP3031A to the Longitudinal Diaphragm at work point E3.

Please reference the pictures attached for more comprehensive details.

Bay # 14: Segment 14 East

This QA Inspector observed the repair welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as Seg3019BB-169. The welder identification was 044722 and observed welding in the 2G (Horizontal) position using approved Welding Procedure Specification WPS-345-SMAW-2G(2F)-FCM-Repair-1. The piece mark was identified as the weld connecting the Vertical Shear Plate Sub Assembly to Bottom Panel. ZPMC performed repair welding in accordance with Critical Welding Report B-CWR2737.

Please reference the pictures attached for more comprehensive details.

Bay # 14: Segment 13BE

This QA Inspector observed the in-process welding by Submerged Arc Welding (SAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as Seg3009-001. The welder identification was 215993 and observed welding in the 1G (Flat) position using approved Welding Procedure Specification WPS-B-T-223(2)1T-1. The piece mark was identified as the weld connecting the Deck Panel to Deck Panel.

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Please reference the pictures attached for more comprehensive details.

Bay # 14: Segment 14 West

This QA Inspector observed the in-process welding by Flux Cored Arc Welding (FCAW) process on a Fillet weld. The Weld joint was designated as Seg3175-001-400. The welder identification was 048433 and observed welding in the 3F (Vertical) position using approved Welding Procedure Specification WPS-B-T-2133-ESAB. The piece mark was identified as the weld connecting the Deck Panel to the Diaphragm.

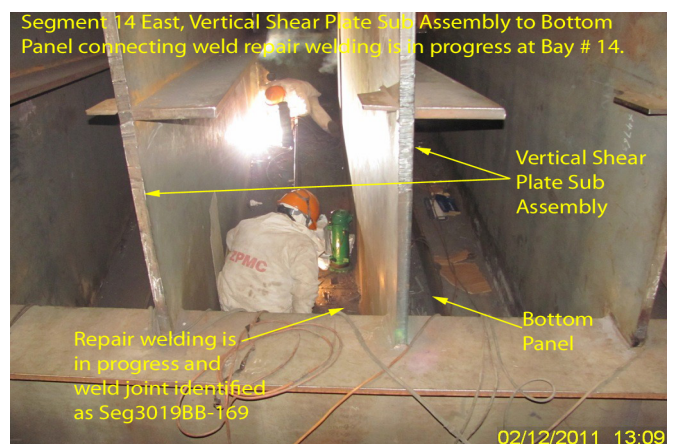
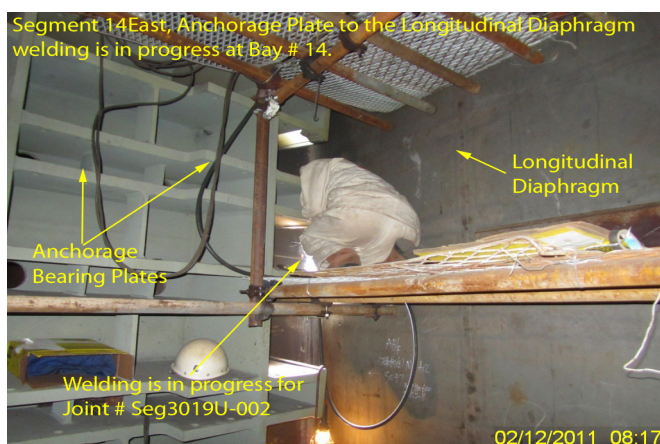
Bay # 14: Segment 14 West

This QA Inspector observed the in-process welding by Flux Cored Arc Welding (FCAW) process on a Fillet weld. The Weld joint was designated as Seg3176-001-333. The welder identification was 203781 and observed welding in the 3F (Vertical) position using approved Welding Procedure Specification WPS-B-T-2133-ESAB. The piece mark was identified as the weld connecting the Deck Panel to the Diaphragm.

Bay # 14 - Segment 13CW

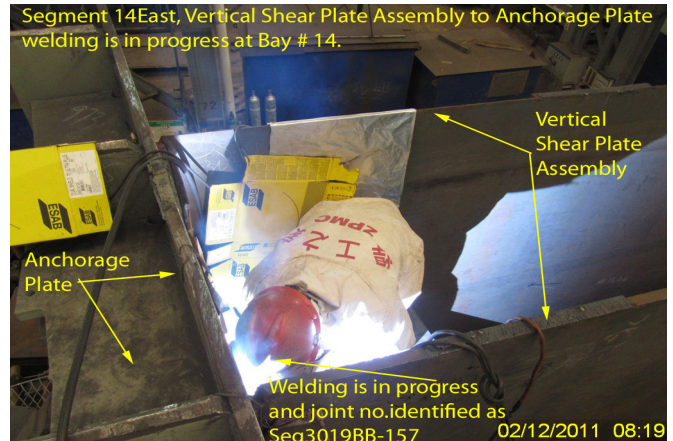
This QA Inspector observed the in-process welding by Flux Cored Arc Welding (FCAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as Seg3015B-005. The welder identification was 201583 and observed welding in the 2G (Horizontal) position using approved Welding Procedure Specification WPS-B-T-2232-ESAB. The piece mark was identified as the weld connecting the Deck Panel Diaphragm to Floor Beam.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Math,Manjunath

Quality Assurance Inspector

Reviewed By: Dsouza,Christopher

QA Reviewer